



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-021
Job Sheet 176039



Part No: D3391-021

Job Qty: 1 ea

Part Name: Fwd Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3391 REV J SHEETS 4,5 IPP A 05.09.13 New issue KJ/JLM IPP B IPP C IPP D 07.03.13 rev F dwg EC IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD IPP Rev:f ECN 1056 07-11-12 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/23/18	5/23/18	0.00	0.00	Start Up Skidtubes-1		M666
100	Skidtubes	1 pcs	5/23/18	5/23/18	0.00	0.82	Skidtubes-4		M666
110	CNC Bend Skidtubes	1 pcs	5/23/18	5/23/18	0.00	1.00	CNC Bend Skidtube		M666
120	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC5		BC
130	CNC Vertical Machining	1 pcs	5/23/18	5/23/18	2.21	1.00	HAAS1-3		K+ 2018/05/20
140	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC2 Machining-2		Kj 2018/05/20
150	Mill Conv	1 pcs	5/23/18	5/23/18	0.00	0.27	Mill Conv 1		M666
160	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC2 Machining-2		18/5/22
170	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC8 Machining-2		18/05/23
180	Skidtubes	1 pcs	5/23/18	5/23/18	0.00	0.82	Skidtubes-4		M666
190	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC5		24 18-5-25
200	HandFinish	1 pcs	5/23/18	5/23/18	0.00	0.33	HandFinish1		SA 18-05-25
210	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC7-2		BE
220	Skidtubes	1 pcs	5/23/18	5/23/18	0.00	0.82	Skidtubes-4		M666
230	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC5		24 18-5-29
235	HandFinish	1 pcs	5/23/18	5/23/18	0.00	0.33	HandFinish2		BE 18-05-29
241	SprayPaint	1 pcs	5/23/18	5/23/18	0.00	0.99	Spray Paint		PO 40046
242	Outsource	1 pcs	5/23/18	5/23/18			ATE003-VC		CX MAY 30 2018
250	QC	1 pcs	5/23/18	5/23/18	0.00	0.00	QC14		24 18-5-31
254	HandFinish	1 pcs	5/24/18	5/24/18	0.00	0.33	HandFinish4		20 18-5-31
256	QC	1 pcs	5/24/18	5/24/18	0.00	0.00	QC5		24 18-6-25
260	Packaging	1 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3-1		24 18-6-26
280	QC21-SA	1 Ea	5/24/18	5/24/18	0.00	0.00	QC21		24 18-6-26

Part Op 100 - Cut as per dwg.

Descriptions: 110 - Bend as per Dwg D3391 Using Bend Prog 3391021

130 - 1-Machine as per Folio FA590 Rev. _____ & Dwg D3391 Rev. _____

150 - Drill X1 Aft cap as per Dwg D3391 .1875" dia

180 - 1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step 2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES

MARKED "A") 6-Deburr & Scribe Batch number Inside aft end. 7-Transfer drill D3391-021 with D3391-023

220 - 1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: 137073 exp. date: 18-08 cure time

12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary
235 - AND REALODINE AS PER QSI 005

003559

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6013-047	Skidtube Material	1 Ea (1 ea)	90-Start up Operation	B86064
D3670-4-200	Bushing	4 Ea (4 ea)	220-Skidtubes	5021404
AELS-1032-225	Insert	10 Ea (10 ea)	254-HandFinish	5058139
AN3C4A	Bolt	10 Ea (10 ea)	254-HandFinish	5041114
D3401-041	Tow Cap Assembly	1 Ea (1 ea)	254-HandFinish	5071282
D3672-1	Washer, Phenolic	4 Ea (4 ea)	254-HandFinish	F150074
D4095-051	Wearpad Fwd	1 Ea (1 ea)	254-HandFinish	M159902-127
NAS1149C0332R	Washer	10 Ea (10 ea)	254-HandFinish	5056493

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6013-047	1	49	0
220-Skidtubes	D3670-4-200	4	48	0
254-HandFinish	AELS-1032-225	10	0	0
	AN3C4A	10	2,277	0
	D3401-041	1	0	0
	D3672-1	4	1,071	0
	D4095-051	1	22	0
	NAS1149C0332R	10	6,563	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 4/16/18 8:29 AM Dart.lajeunesse.marie

Container No: S064618



Part: D3391-021

Job No: 176039

Serial No/Batch: S064618

Revision:

Inspector:

Date: 04/24/18

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



D4095-051
WEARSHOE

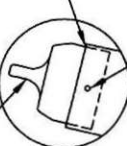
INSTALL
AELS-1032-225
AFTER FINISH
10 PL

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291

D3401-041
TOW CAP

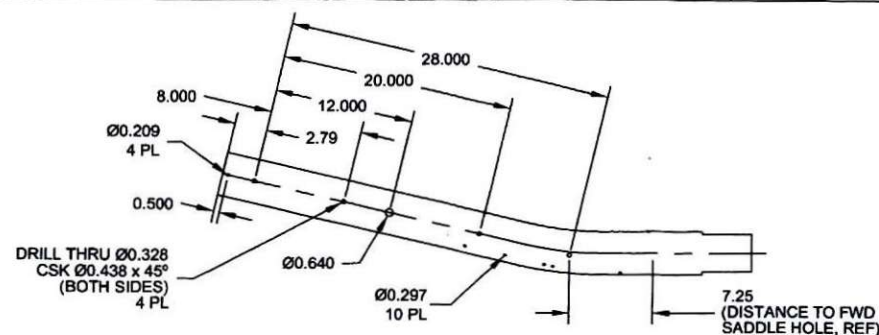


AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

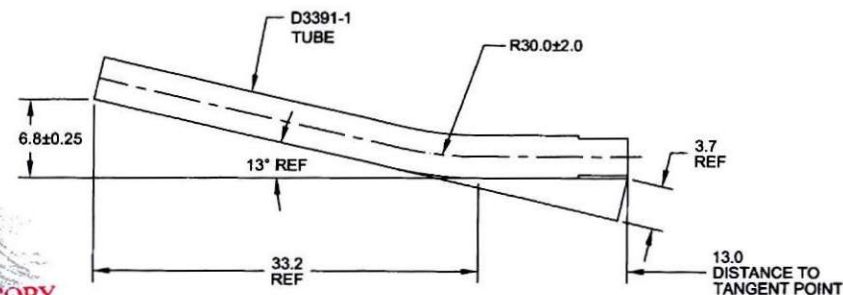
DETAIL B SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



D3391-021 DRILLING DETAIL

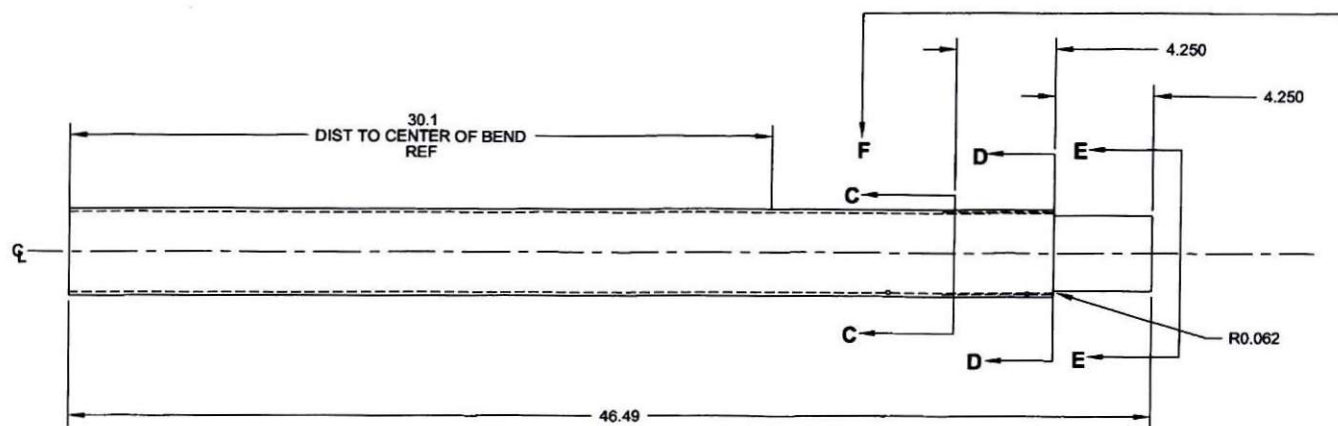


D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

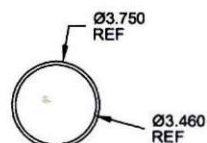
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 176038 MLW
180476

RELEASED
2016-04-28

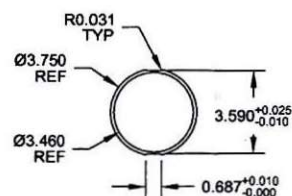
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DS	D3391	SHEET 4 OF 11
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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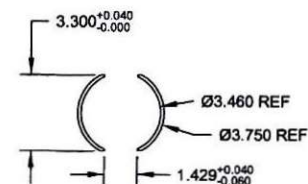
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



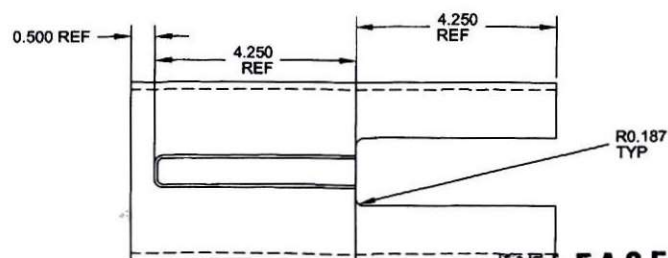
SECTION C-C



SECTION D-D



SECTION E-E



VIEW F-F
SCALE 2X

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	<i>CP</i>	D3391	SHEET 5 OF 11
APPROVED	<i>CP</i>	TITLE	SCALE
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Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040046**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO040046
PO Date: 5/30/18
Due Date: 5/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176039	D3391-021	Fwd Tube Assembly	Firmed	5/30/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
	176040			Firmed	5/30/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
Sub Total:						2	0	2		\$250.00
2	175483	D3391-025	Aft Tube Assembly	Firmed	5/30/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
	176047			Firmed	5/30/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
Sub Total:						2	0	2		\$250.00
Grand Total:										\$500.00

Order Notes

reid A1905/30

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL

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